

Work Order ID 63992

Tuesday, November 23, 2010 9:24:44 AM



Page 1

Item ID:	D2230-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Lug				Stop	
Start Date:	11/22/2010	Start Qty: 80.00		Cust Item ID:		
Required Date:	11/30/2010	Req'd Qty: 80.00		Customer:		
Reference:						

Approvals:	Process Plan:	<i>PL</i>	Date:	<i>10-11-23</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2230	Rev G

100		0.00
	BAND SAW	
Bandsaw		0.00
Jeaspa Bandsaw		

Memo
Cut D2423 extrusion to 0.82"
Batch: _____
cut @ ymetec

110		0.00
	HAAS CNC VERTICAL MACHINING #1	
HAAS		0.00
HAAS CNC vertical machine #1		

Memo
1-Machine per folio FA927
FOLIO REV: _____
DWG REV: _____
Check for crack while loading into the machine.
2- deburr

CL 10/11/23 (80)

Purchasing

issue P10 to ymetec
Machine as per dwg D2230 Rev.G

P10:13000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____


NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries


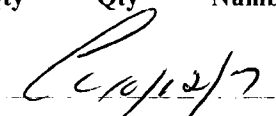


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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Rec'd Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo rec'd + inspect for transit damage.	0.00 0.00							 10/12/7 (80)
130  QC Quality Control	QC6 Inspect parts - second check Memo	0.00 0.00							Winton (80)
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							80 H 10-12-7.

W/O:		WORK ORDER CHANGES					
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Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence II/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 2) M	10/12/07			80	0		
170 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M115951. Memo START TIME: 8:20 OVEN TEMPERATURE: 300° FINISH TIME: 8:50	0.00 0.00				80	0	10-12-8	
180 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	10/12/08			80	0		

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Page 4

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Start Date: 11/22/2010 Start Qty: 80.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 80.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 476

0.00



Packaging

Memo

0.00

Packaging

10/12/08

800

sf

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/08

MF
10-12-08

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Picklist Print

Tuesday, November 23, 2010 9:24:47 AM

Page 1

Work Order ID: 63992



Parent Item: D2230-3



Parent Item Name: Lug

Start Date: 11/22/2010

Required Date: 11/30/2010

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP ☐ D ☐ 00.05.18 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC
IPP REV :E NEW FOLIO # 10-05-
25 JLM VERIFIED BY:EC
☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No			100	f	298.8644	0.0683	5.751579			
-------	--	--------------	----	--	--	-----	---	----------	--------	----------	--	--	--



Lug Extrusion



CY 10/11/25

Location

Loc Qty

Loc Code

MAT06

298.8644265

43722

180

45800

118.864426

5.75

W/O:		WORK ORDER CHANGES					
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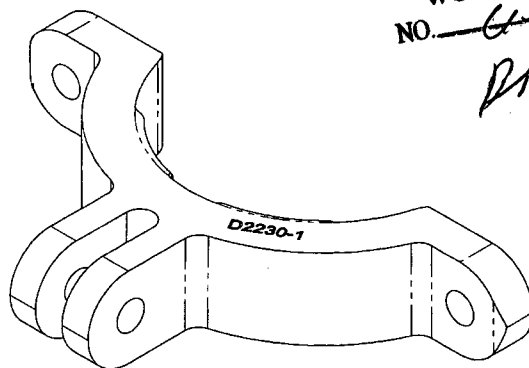
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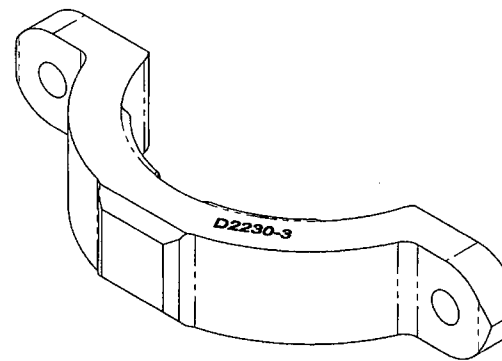
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 63992
PL10 11-23



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
09/01/16



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005 .
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2230	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
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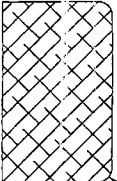
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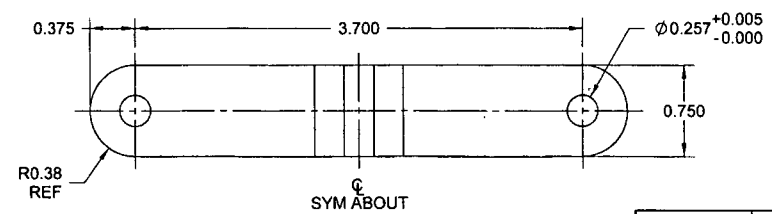
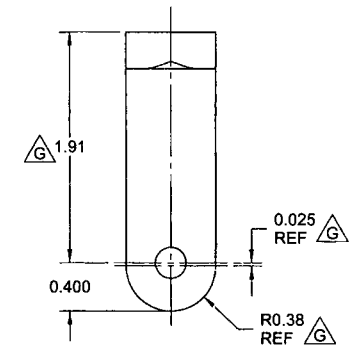
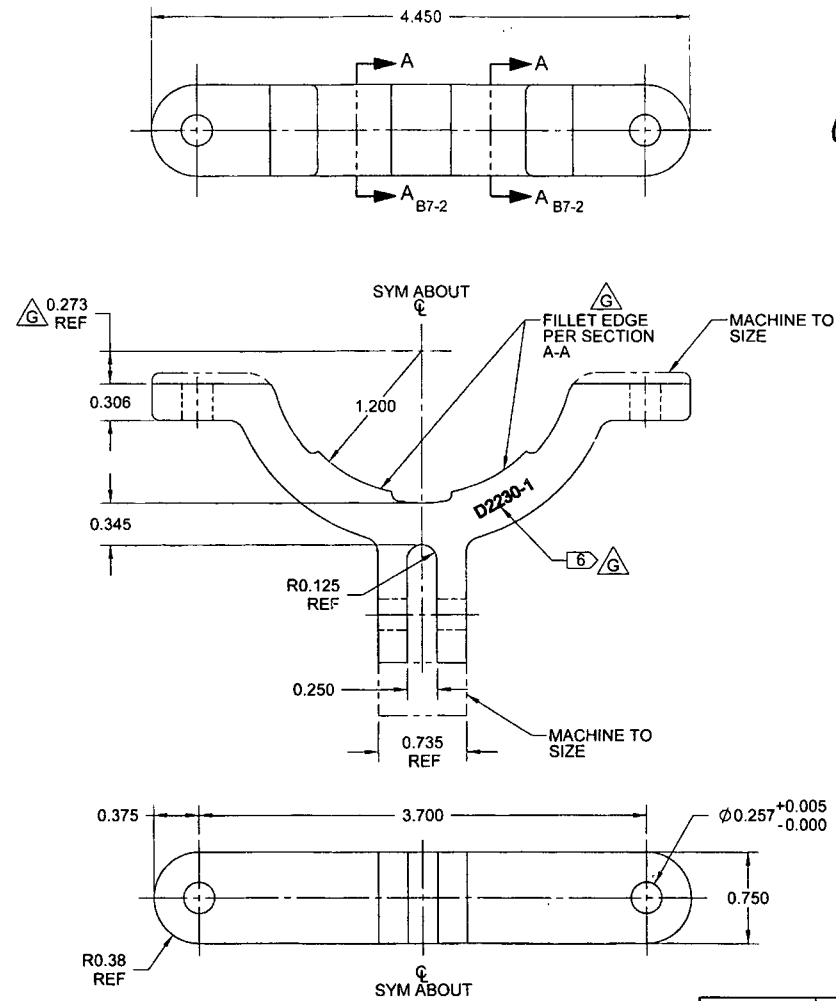
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u63992

 R0.06 MIN - R0.10 MAX
2 PL
SECTION A-A D4.2
SCALE 2X



D2230-1 MOUNTING LUG

RELEASED
09/06/25/17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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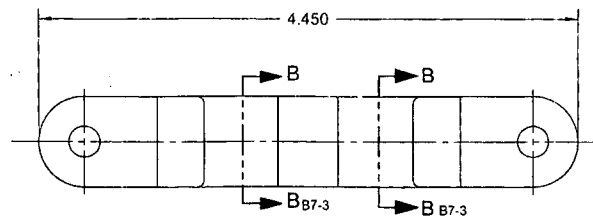
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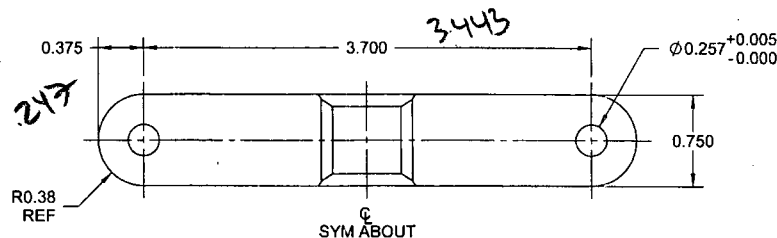
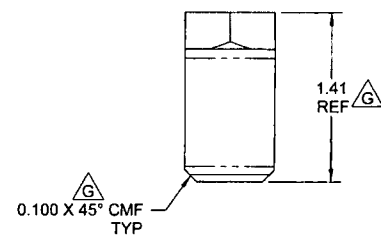
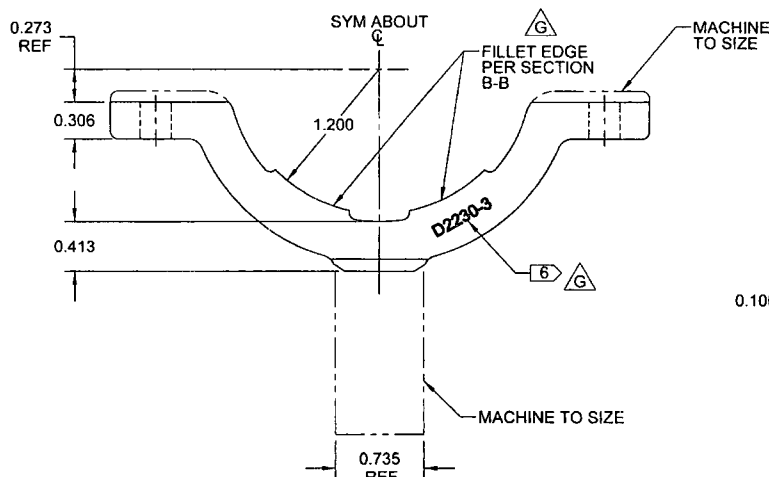
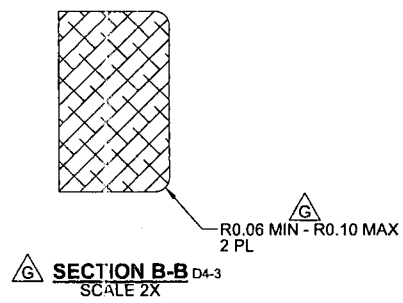
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al643298



D2230-3 MOUNTING LUG

RELEASED
09/06/25

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13000

Purchase Order Date 11/24/10

PO Print Date 11/24/10

Page Number 1 of 2

Order From :
METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

VC-MET003

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 678 3957	Requisition Nbr	
Vendor Fax	613 678 3956	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID
12/11/24

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
D3910-3P		Crosstube Lug	11/29/10 Yes	30.00 Each		\$31.5500	\$946.50
		Special Inst:	MACHINE AS PER DWG D3910 REV. B B63333 REQUIRED ASAP PLEASE RUSH ORDER				
D3910-1P		CROSSTUBE LUG	12/01/10 Yes	20.00 Each		\$31.5500	\$631.00
		Special Inst:	MACHINE AS PER DWG D3910 REV. B B64016				
D2230-1P		LUG	12/06/10 Yes	60.00 Each		\$18.9500	\$1,137.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B63319				
D2230-3P		LUG	12/08/10 Yes	60.00 Each		\$10.4000	\$624.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 11/24/10



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17614

Date: \

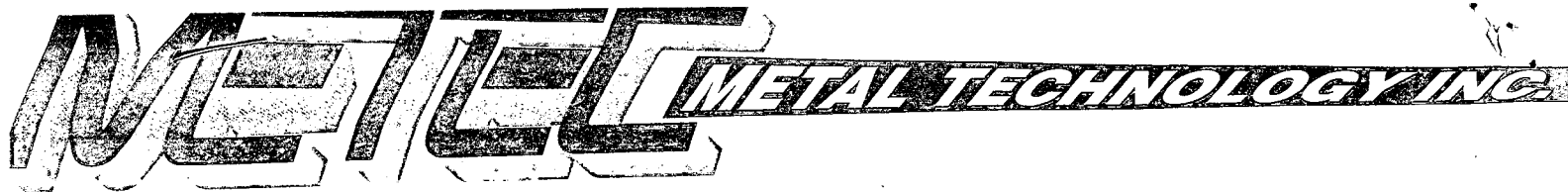
Dec 06, 2010

Page:

1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13000	Sold By:
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3910-3 Crosstube Lug	Each	30		
D3910-1 Crosstube Lug	Each	20		
D2230-1 Mounting Lug	Each	60		
D2230-3 Mounting Lug	Each	60		60
D2230-3 Mounting Lug	Each	80	80	
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

80

D2230-3

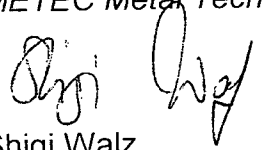
Mounting Lug

13000

MATERIAL: supplied by DART D2423 B45800

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

8.10.12/07

Vankleek Hill, December 6, 2010